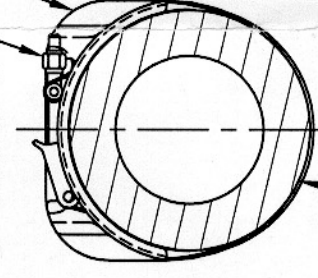


02.06.04

67.12.04 5

Magistrate, City of
Sofia







D2940-1 SUPPORT (REF) -
MS21920-28 CLAMP (REF) 7

GENERAL NOTES:
1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 2) MATERIAL: MANUFACTURE FROM D6008-180
FINISHED LENGTH = 146.98
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 6) Scribe DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS
- 7) INSTALL D2856-600-1009 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2940-1 SUPPORT, PER QSI 035
- 8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 9) SEAL EDGES OF SUPPORTS USING SIKAFLEX-241/-291 SEALANT (OPTIONAL)
- 10) TORQUE CLAMPS 80 TO 100 IN-LB

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A	02.05.27	NEW ISSUE	
DESIGN		DRAWN BY	
CHECKED		APPROVED	
DATE	02.05.27	D205-596-103 DRAWING NO. REV. A SHEET 1 OF 1 SCALE XTUBE ASS'Y (HI-HI AFT) 1:10	

XTUBE ASS'Y (HI-HI AFT)

1:10